

Work Order ID 60571 - 1

Wednesday, July 14, 2010 9:20:18 AM



Page 1

Item ID: D3393-041

Accept



Setup Start



Revision ID:

Item Name: Battery Lock Assembly

Stop



Start Date: 7/14/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: *H*

Date: 10-7-14 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr Revision Nbr

D3393 Rev A

100



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

1-Open D3373-1 lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest. 2-Using the flat cam, fabricate D3369-5 as per Dwg D3369 Identify as D3369-5 3-Assemble D3393-041 as per Dwg D3393. Insert lock body and fasten

SB 10/10/03

(3)

110



Large Fab

Large Fab

0.00

Memo

0.00

Large Fab

Tack Weld lock shaft to flat cam of a Max 1/8" Long. Qty Part Number Description Batch ☐ A/RN/A SS Rod *111585*

(3)

PL 10.10.04

120



QC

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

Quality Control

BE 10.11.04

3

φ

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Item Name: Battery Lock Assembly

Start Date: 7/14/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Apply Crazy Glue to cap and press into Body Batch: <u>M115663</u>	9567K21		SB 10/11/04					
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00		S101464					
150 	Identify as per dwg & Stock Location: <u>487</u>	0.00		REDA					
Packaging Packaging	Memo	0.00							

(3)

(x3)

10/11/451 (3p)

Work Order ID 60571

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Item ID: D3393-041

Revision ID:

Item Name: Battery Lock Assembly

Start Date: 7/14/2010 Start Qty: 5.00

Required Date: 7/22/2010 Req'd Qty: 5.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/
Run Hours

0.00

0.00

Accept



Cust Item ID:

Customer:

Setup Start

Stop

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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10/11/04 [Signature]

10-11-04
(3)

Checklist Print

Wednesday, July 14, 2010 9:20:22 AM

Page 1

Work Order ID: 60571



Parent Item: D3393-041



Parent Item Name: Battery Lock Assembly

Start Date: 7/14/2010

Required Date: 7/22/2010

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A New Issue 05-11-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

5/16WC

Purchased

No

100

Each

2,111.000

2

10



SS Flat Washer 5/16

Location

Loc Qty

Loc Code

ST377

2111

112560

239

114758

77

115072

1000

115110

295

115174

500

9567K21

Purchased

No

100

Each

69.0000

2

10



Polyethylene Cap

Location

Loc Qty

Loc Code

ST380

69

110822

69

D2728-7

Manufactured

No

100

Each

0.0000

0

0



Dart Logo label

D3373-1

Manufactured

No

100

Each

35.0000

1

5



Cam Lock

Location

Loc Qty

Loc Code

ST052

35

44105

2

58463

33

10

14 SB 10/11/02

6 SB 10/11/04

SB 10/11/02

SB 10/11/02

cklist Print

Wednesday, July 14, 2010 9:20:22 AM

Work Order ID: 60571

Parent Item: D3393-041

Parent Item Name: Battery Lock Assembly



Start Date: 7/14/2010

Required Date: 7/22/2010

Start Qty: 5.00

Required Qty: 5.00

D3393-1

Manufactured No

100 Each 0.0000

1

5



Battery Lock Casing

B 89773



SP 10/16/02

D3393-3

Manufactured No

140 Each 7.0000

1

5



Cam Lock Shaft



SP 10/16/02

Location

Loc Qty

Loc Code

ST055

7

48630

7

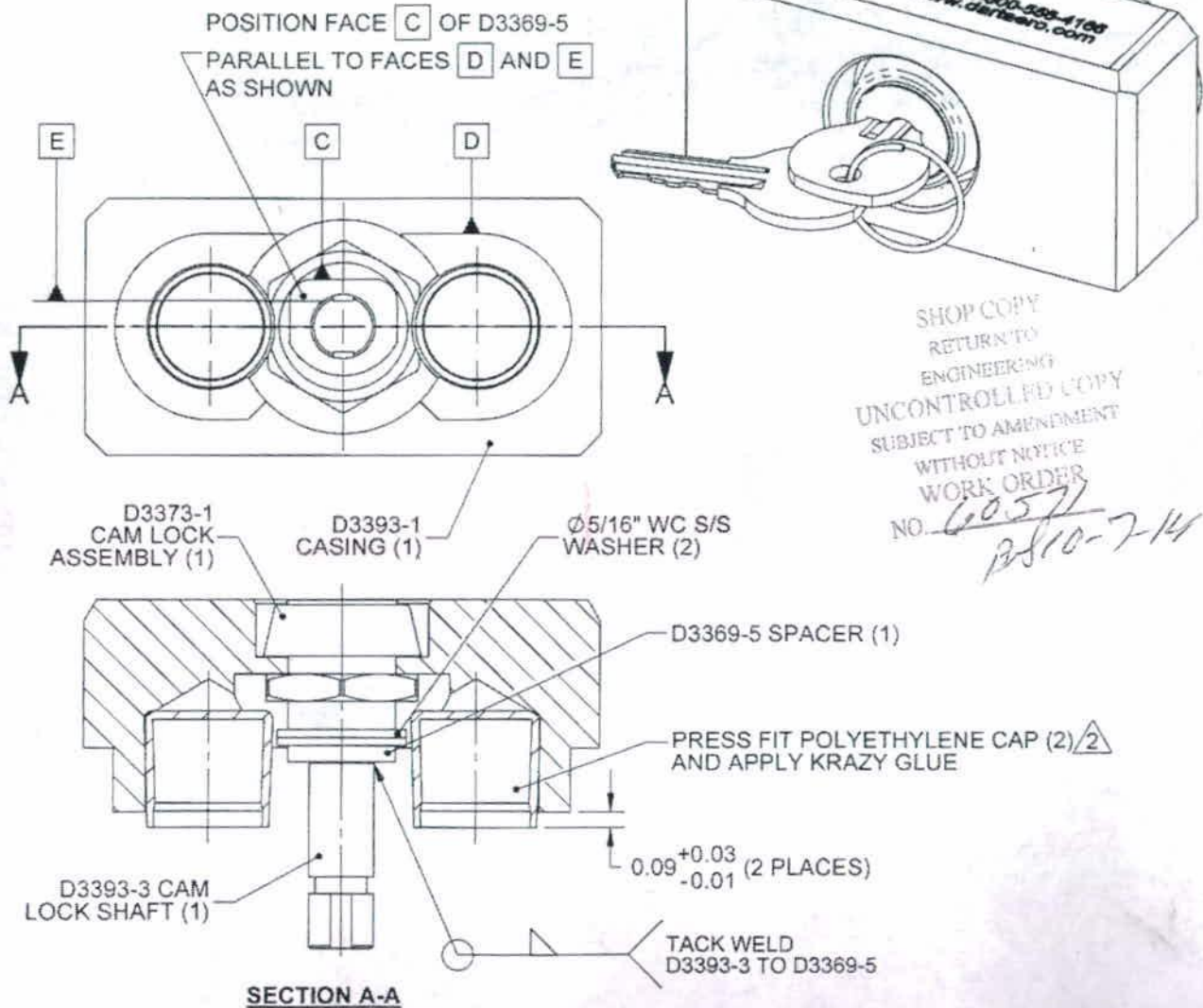
7

DART

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A SHEET 1 OF 3
DATE 05.02.08		TITLE BATTERY LOCK	SCALE 1:1
A	05.02.08	NEW ISSUE	

RELEASED
[Signature]

05/03/09

**D3393-041 BATTERY LOCK ASSEMBLY****NOTES:**

- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 9567K21

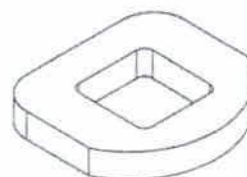
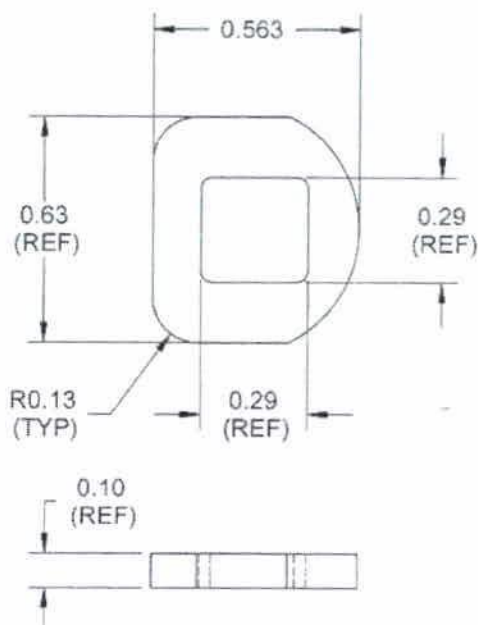
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3369	REV. A SHEET 4 OF 4
DATE 04.12.16		TITLE BATTERY LOCK	SCALE 2:1

SPECIFICATION CONTROL DRAWING



RELEASED
[Signature]
05/02/11

REFERENCE ONLY

-5
D3369 SPACER



NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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